

# Work Order ID 47622

November 17, 2009 7:56:59 AM



Page 1

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 11/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *CL*

Date: *09/14/17*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2991	D
DSI 9463 → NOT APPLICABLE →	
IIN-D350-589	E

D2991

D

DSI 9463 → NOT APPLICABLE → *MP 10/4/28*

IIN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-042/ DSI 9463  
CHG005

*5/10/04/08*

*PT 10-4-28*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*25 10-04-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 47622**

November 17, 2009 7:56:59 AM



Page 2

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 11/17/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D2991 &amp; IIN D350-589 and install label as per dwg

RT 10-04-28

ATO

150

0.00



QC5- Inspect part completeness to step on W/O

S. W. G. 10/28

QC

Memo

0.00

Quality Control

40

160

0.00



Pick Kit

Packaging

Memo





















0.00

Packaging

10-4-28 12 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-04-28	140						

Part No: D350-589-042 PAR #: N/A Fault Category: Supplier NCR: Yes No DQA: 1 Date: 10.05.03  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 10 Date: 10/05/03

NCR: 47622		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-04-28	140	Bottom LH corner has cracks in Gel coat + primer due to shipping LL not Packages properly		sand down gel coat + primer to cloth to ensure that there are no cracks in composite	BT 10-04-27			
				QC 5	BT 10-04-27	10-04-27	Q92417	10-04-27
				Brush on a light coat of Hysol 95C B 112167	BT 10-04-27			
				to smooth surface		10-04-27	Q92412	10-04-27
				sand smooth re prime inside of door as per Q52005 primer B 113582	BT 10-04-27			
				re-paint outside of door as per Q52005 using imron B 114015				
				QC 14	BT 10-04-27	10-04-27	Q92417	10-04-27
				QC 5	BT 10-04-27			

NOTE: Date & initial all entries

**Work Order ID 47622**

November 17, 2009 7:56:59 AM

Page 3

Item ID: D350-589-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Side Door Assembly RH

Start Date: 11/17/09 Start Qty: 1.00

Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 1.00




Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00	5/04/28			PO			Pho →
180  Packaging Packaging	Memo Identify and pack for shipping as per PPP D350-589-042/ DSI 9463 Location: <u>8</u> PPP rev: _____	0.00  0.00	10-4-28						SP
190  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00	10/04/28						MF 10-4-28

W/O: 47622		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
6/4/28	# 100	Perm. Change Per DSZ-9446-011 + DSZ-9447-011 Missin parts. ADD to kit D3894-1 Qty x1 per kit B <u>46896</u> D3895-1 Qty x1 per kit B <u>1345585</u>	SL	10-4-28			S 10/04/28	
10/4/28	# 100	update w/o + BOM. <del>ADD copy of new BOM as Ref.</del>	AA	10.04.28			S 10/04/28	

Part No: D350-589-042 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

November 17, 2009 7:56:58 AM

Page 1

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2991-2RevU/R		Manufactured	No			110	Each	0.0000	1.0000			
Side Door												
D2621 RevB		Manufactured	No			110	Each	66.0000	4.0000	3		
Latch Plate, 350 Spacepod												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

66

46842

66

D2586RevD

Manufactured No

110

Each

104.0000

4.0000

3

Door Latch

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104

23082

0

45554

1

47183

3

50213

100

55314 + 3

ST 10-04-26

ST 10-04-27

X3

ST 10-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November 17, 2009 7:56:58 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No			110	Each	178.0000	4.0000	3.44		



Screw

BT 10-04-27

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	178	
106903	3	
108169	4	
109321	4	
111916	67	
112794	100	

D2464-1700RevB Manufactured No



Neoprene Seal

D3085-041RevA1 Manufactured No



prop ass'y

110 Each 0.0000 1.0000

B48173

BT 10-04-28

110 Each 6.0000 1.0000

BT 10-04-27

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6	
47186	2	
47687	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 17, 2009 7:56:59 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH


Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585RevB  Mounting Channel		Manufactured	No			110	Each	45.0000	4.0000 3 11			

ST 10-04-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

41

50544

2

51526

39

356524 x 3

MS21042L3

Purchased

No

110

Each

3,038.000

4.0000 3 11



Nut

ST 10-04-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

113644 x 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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November 17, 2009 7:56:59 AM

Work Order ID: 47622



Parent Item: D350-589-042RevC



Parent Item Name: Side Door Assembly RH

Start Date: 11/17/09

Required Date: 12/04/09

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD10

Purchased

No

110

Each

2,498.000

4.0000

3 AA



Washer

4151149 003635

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2498

105442

19

109059

2

109840

23

110985

202

111279

5

111668

64

112314

965

112369

218

113149

1000

B 114292 x3

ST 10-04-27

MS20470AD4-5

Purchased

No

160

Each

2,621.000

8.0000



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2621

111916

2621

8

10-4-28 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 17, 2009 7:56:59 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-4A		Purchased	No			160	Each	2,137.000	6.0000			

Bolt

10-4-28 SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2137	
103915	78	
104214	500	
104291	300	
104322	200	
104374	200	
104625	300	
104817	559	

D2237RevD1

Manufactured No

160 Each

75.0000 4.0000

Striker Plate

2  
155006 155312 10-4-28 SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5	
46162	5	
Main Warehouse		
ST022	70	
50348	15	
52327	55	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

November 17, 2009 7:56:59 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH

Comments: IPP RevE: per DSI 9463 DD verified by:

Start Date: 11/17/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2589RevA

Manufactured

No

160

Each

60.0000

1.0000

Keys, Key Chain, 350 Hinge

C-2-32-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

46840

20

50378

40

MS21042L3

Purchased

No

160

Each

3,038.000

6.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# D2991-1/-2/-3 SIDE DOOR

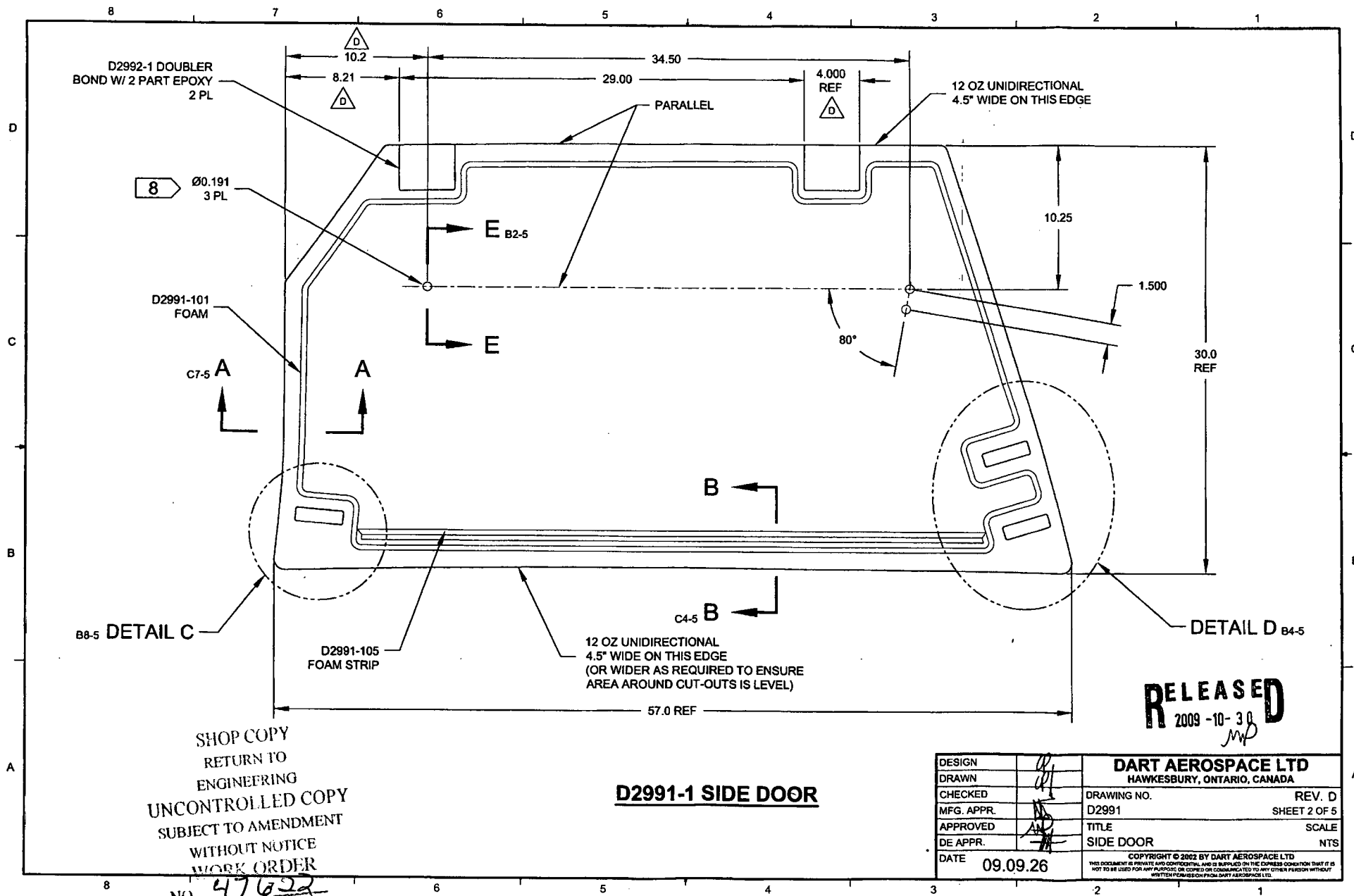
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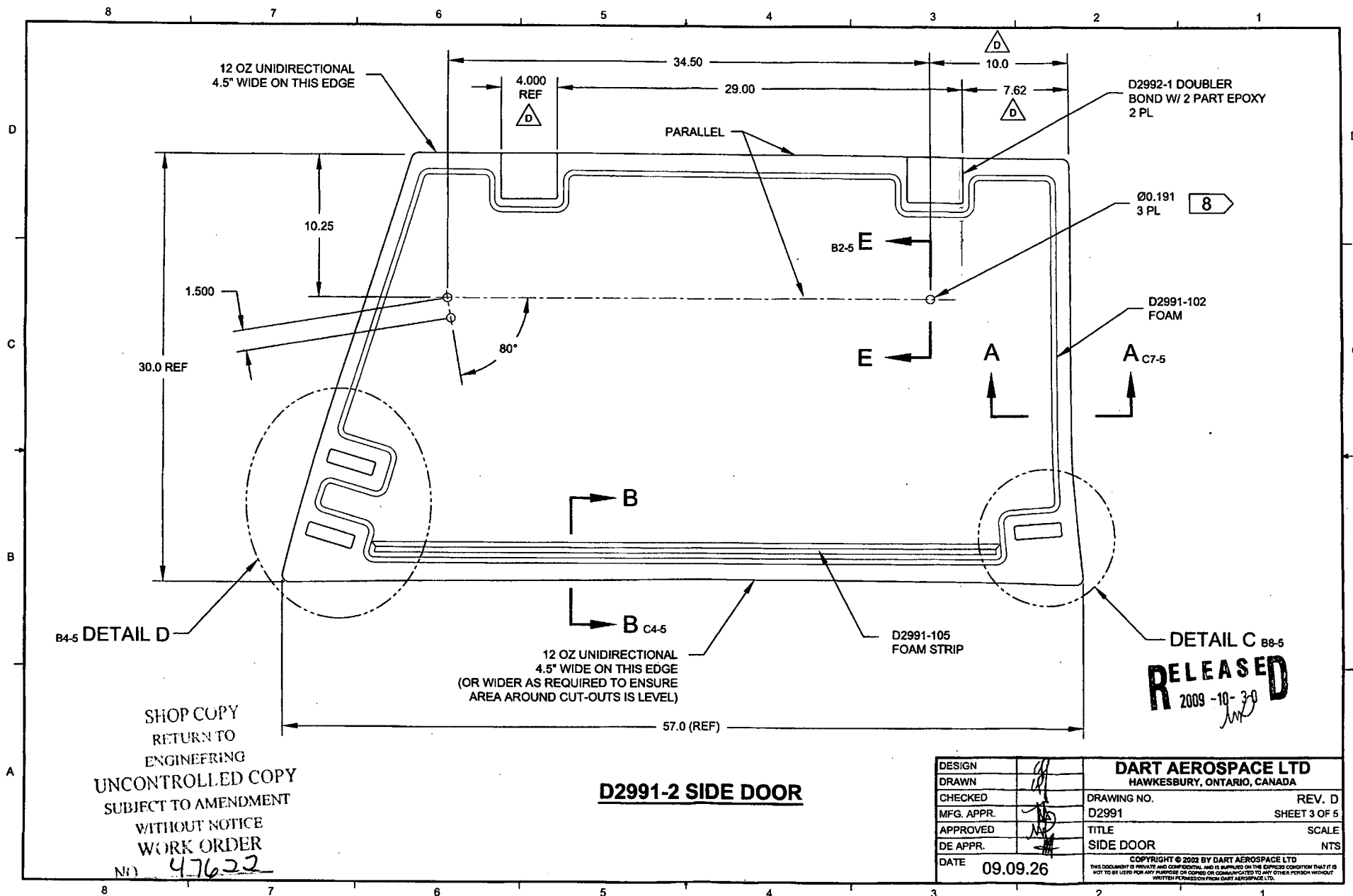
- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47622  
C209/11/17

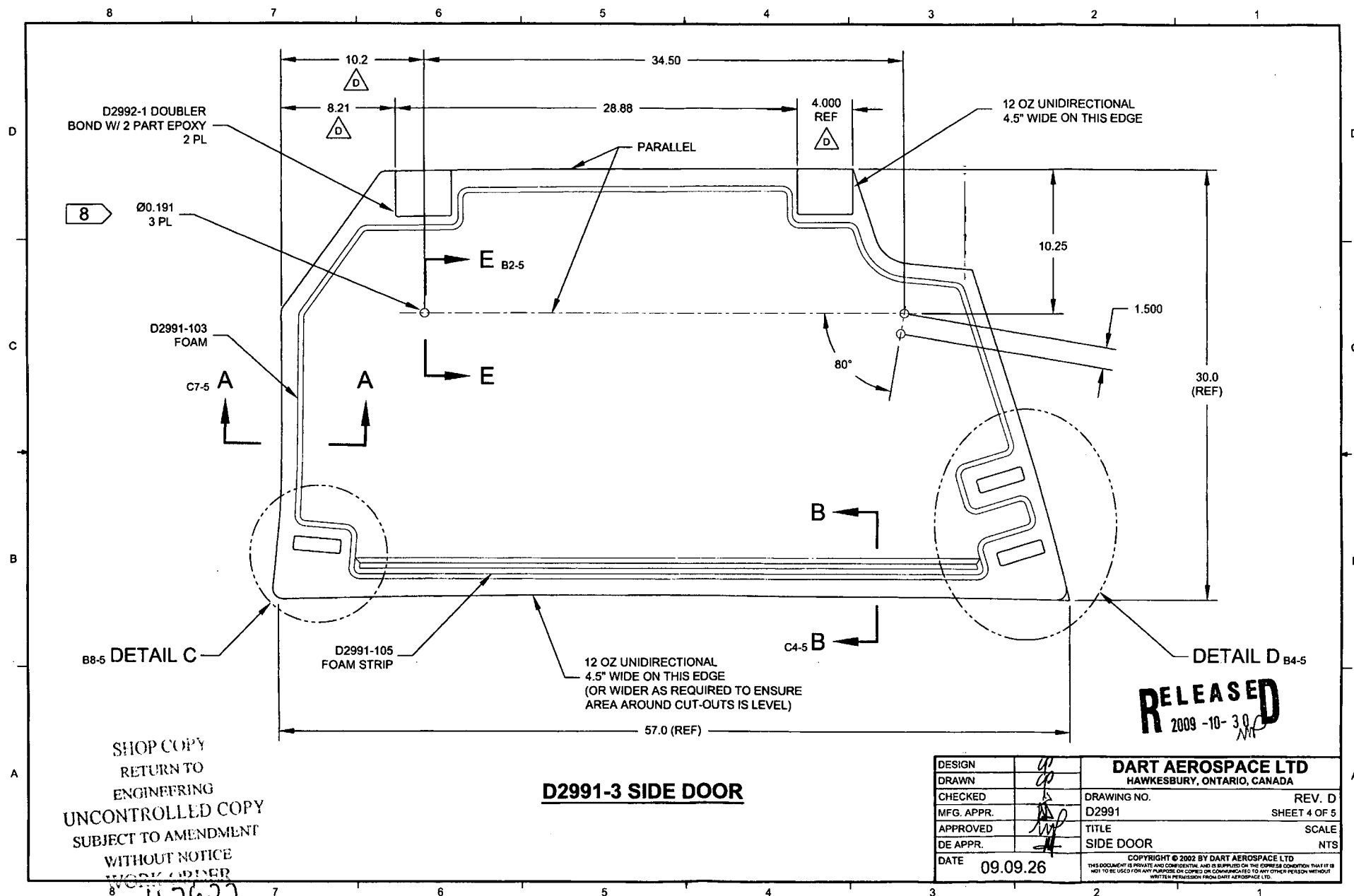
RELEASED  
2009-10-20  
*MP*

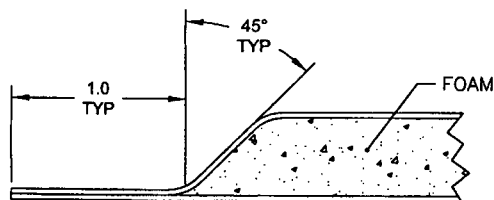
D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE		09.09.26	
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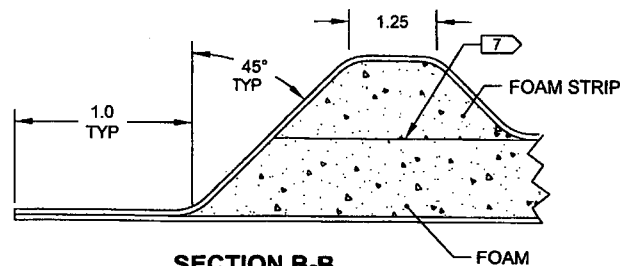


DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.		TITLE SIDE DOOR	SHEET 3 OF 5
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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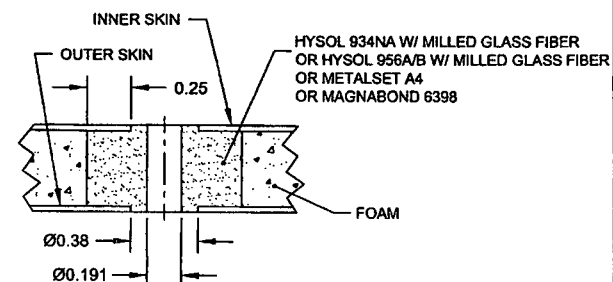




**SECTION A-A** C7-2, C2-3, C7-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE

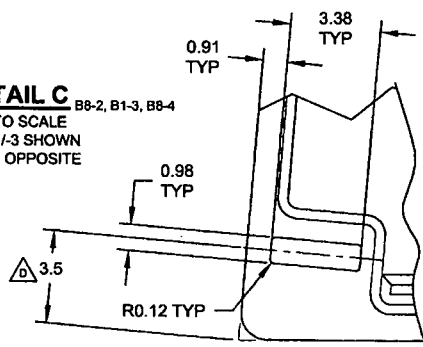


**SECTION B-B** B4-2, B5-3, B4-4  
ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE

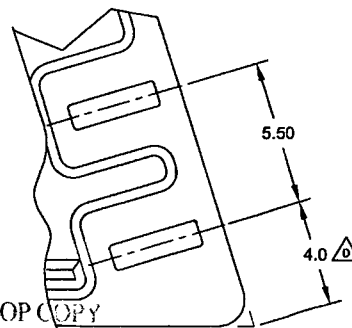


**SECTION E-E** D6-2, D3-3, C6-4  
TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE

**DETAIL C** B8-2, B1-3, B8-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



**DETAIL D** B1-2, B8-3, B1-4  
NOT TO SCALE  
D2991-1/-3 SHOWN  
D2991-2 OPPOSITE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 47622

**RELEASED**  
2009-10-30  
M4

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SIDE DOOR	SCALE
DE APPR.			NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**Work Order ID 47622**

Friday, June 26, 2009 10:46:57 AM



Page 1

Item ID: D350-589-042

Accept



Setup Start



Revision ID: C

Stop



Item Name: Side Door Assembly RH

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2991	Rev C
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D350-589-042 CHG002

110

0.00



Purchasing

Purchasing

Memo

0.00

Purchasing

Issue P/O: \_\_\_\_\_ ☐ Description: D2991-2 side  
door ☐ Supplier: Delastek batch: ☐ Ship to  
delastek: Qty 2 D2992-1 Doubler ☐ Ensure batch # on  
Label D3721-2 match W/O # for D350-58

120

0.00



Receive &amp; Inspect for Damage &amp; Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached



**Work Order ID 47622**

Friday, June 26, 2009 10:46:57 AM



Page 2

Item ID: D350-589-042

Accept



Setup Start



Revision ID: C

Stop



Item Name: Side Door Assembly RH

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D2991

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D2991 &amp; IIN D350-589 and install label as per dwg

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

**Work Order ID 47622**

Friday, June 26, 2009 10:46:57 AM



Page 3

Item ID: D350-589-042

Accept



Setup Start



Revision ID: C

Stop



Item Name: Side Door Assembly RH

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							
170 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							
180 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							

**Work Order ID 47622**

Friday, June 26, 2009 10:46:57 AM



Page 4

Item ID: D350-589-042

Accept



Setup Start



Revision ID: C

Stop



Item Name: Side Door Assembly RH

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Page 1

Friday, June 26, 2009 10:46:56 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH



















Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2992-1RevU/R 		Manufactured	No			120	Each	0.0000	2.0000 			
Doubler												
MS21042L3 		Purchased	No			120	Each	0.0000	3.0000 			
Nut												
AN960JD10 		Purchased	No			140	Each	0.0000	3.0000 			
Washer												
D2464-1700RevB 		Manufactured	No			140	Each	0.0000	1.0000 			
Neoprene Seal												
D2585RevB 		Manufactured	No			140	Each	0.0000	3.0000 			
Mounting Channel												
D2586RevD 		Manufactured	No			140	Each	0.0000	3.0000 			
Door Latch												
D2621RevB 		Manufactured	No			140	Each	0.0000	3.0000 			
Latch Plate, 350 Spacepod												
D2991-2RevU/R 		Manufactured	No			140	Each	0.0000	1.0000 			
Side Door												
D3085-041RevA1 		Manufactured	No			140	Each	0.0000	1.0000 			

prop ass'y

# Picklist Print

Page 2

Friday, June 26, 2009 10:46:56 AM

Work Order ID: 47622

Parent Item: D350-589-042RevC

Parent Item Name: Side Door Assembly RH













Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			140	Each	0.0000	6.0000 			
Nut MS27039-1-15 		Purchased	No			140	Each	0.0000	3.0000 			
Screw AN3-4A 		Purchased	No			170	Each	0.0000	6.0000 			
Bolt D2237RevD1 		Manufactured	No			170	Each	0.0000	3.0000 			
Striker Plate D2589RevA 		Manufactured	No			170	Each	0.0000	1.0000 			
Keys, Key Chain, 350 Hinge D3721-2RevA 		Manufactured	No			170	Each	0.0000	1.0000 			
Decal MS20470AD4-5 		Purchased	No			170	Each	0.0000	6.0000 			
Rivet, Universal Head												

Friday, June 26, 2009 10:46:56 AM

Shop Packet Print

Page 2

Date: Wednesday, 29/04/2009 3:06:40 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SIDE DOOR
Job Number	: 47622		
Estimate Number	: 12296		
P.O. Number	:	Part Number	: D350589042
This Issue	: 29/04/2009 S.O. No. :	Drawing Number	: D2991 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 47621	Material	:
Written By	:	Due Date	: 20/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	: est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN1096 DD verified by: EC est rev C 08.06.26 revised pick list per QC comments (w/o25886) EC verified: DD est rev D 09.02.18 ecn 09-523, chg003 EC verified:DD		



## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D350-589-042

CHG003

CHG 004

PTD 406.05.01

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES-ENGINEERING
-----	-----------------	------------------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8723

Description: D2991-2 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1

Doubler

batch:

B46789

C209/05/04-2

Ensure batch # on Label D3721-2 match W/O # for D350-589-042

Certificate of Conformity and process sheet from Delastek is required

3.0	D29921	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

4.0	D29912	Side Door
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Side Door

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.05.01	1	KITS NOW AT CHG 004 W/ 4.00" WIDE DZ992-1 DOUBLER					
09.05.01	2	SHIP MODIFIED DZ992-1 DOUBLER: 4.00" WIDE x 3.250" TALL x 0.040 THICK SUSZ-H3Z W/ R0.250 CORNERS BIN					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:06:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47622

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



### ENGINEERING APPROVAL

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2464-1700	Foam seal	

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2585	Latch clamp	

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2586	Door latch	

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2621	latch plate	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:06:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47622

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3085-041	prop ass'y	

12.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	AN960JD10	Washer	

13.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS21042L3	Nut	

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	MS27039-1-15	Screw	

15.0

D37212

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Decal

batch: \_\_\_\_\_

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:06:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47622

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick kit:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch: \_\_\_\_\_

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch: \_\_\_\_\_

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
3	D2237	Striker Plate	_____

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2589	keys, key chain	_____

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	AN3-4A	Bolt	_____

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 29/04/2009 3:06:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 47622

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS20470AD4-5	Rivet	

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**POSITIVE RECALL**

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

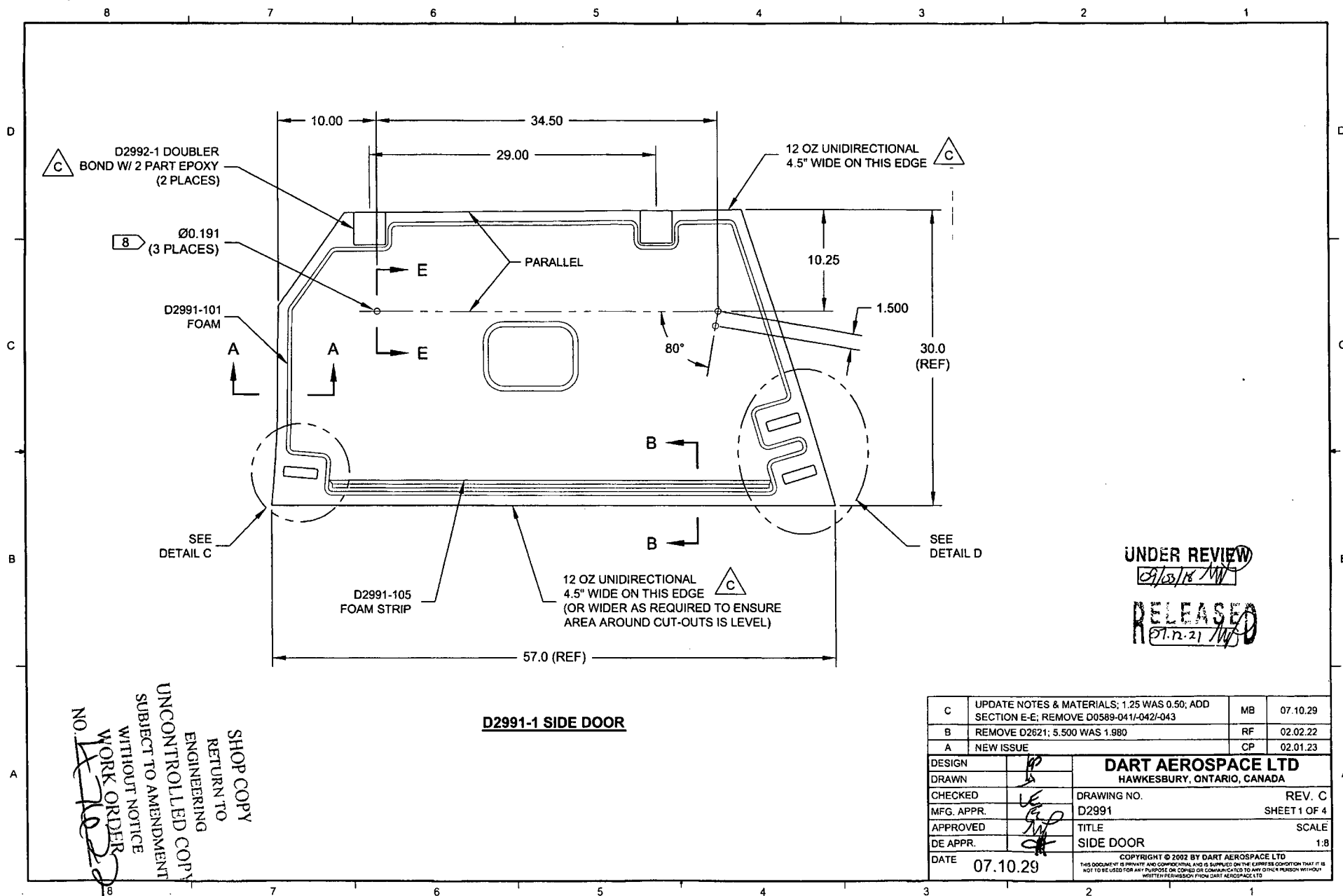
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

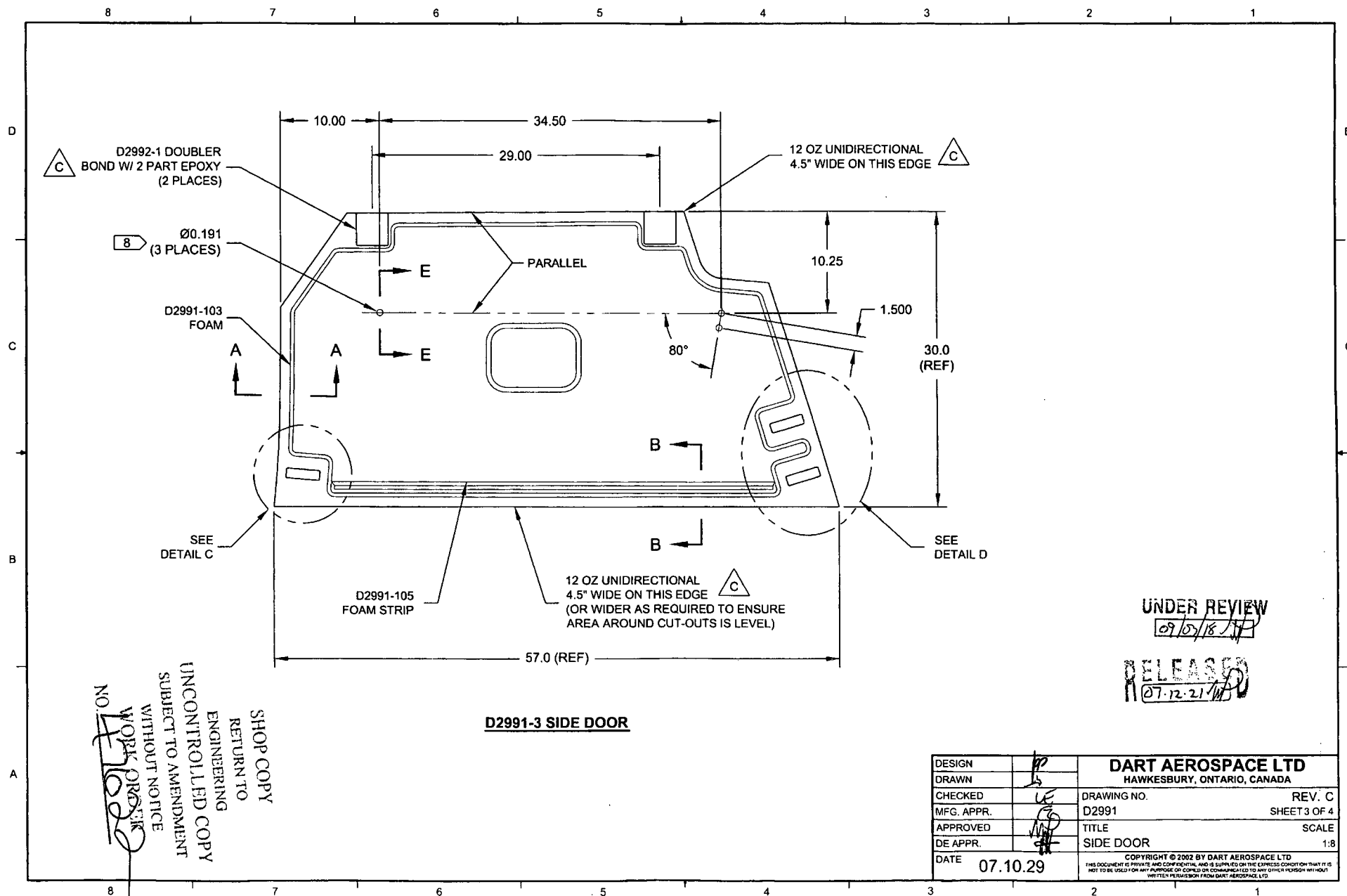
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries















**D2991-3 SIDE DOOR**

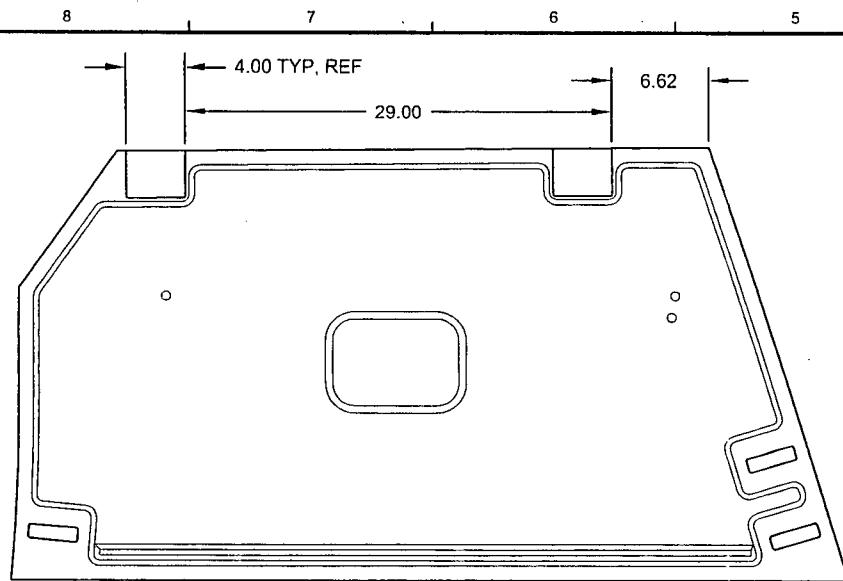
UNDER REVIEW

09/05/18

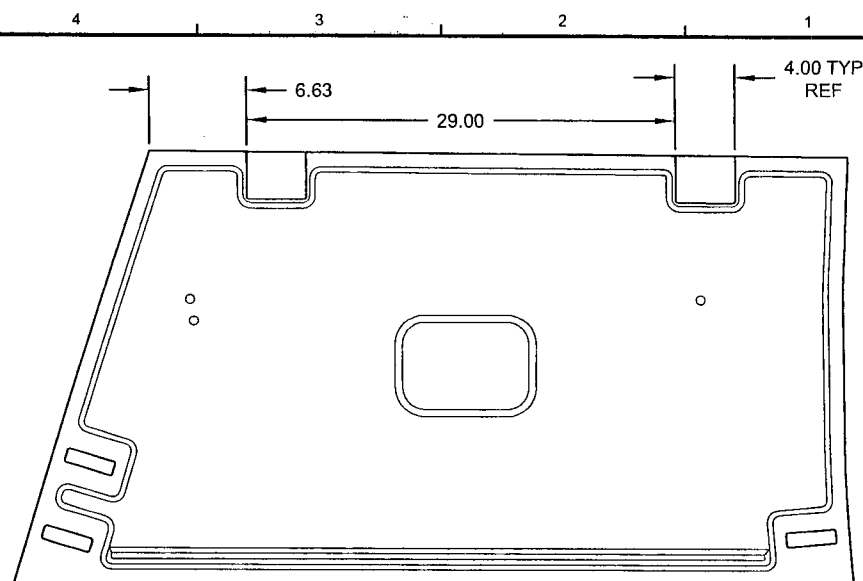
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07-12-21

NO. 471002  
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RETURN TO  
SHOP COPY

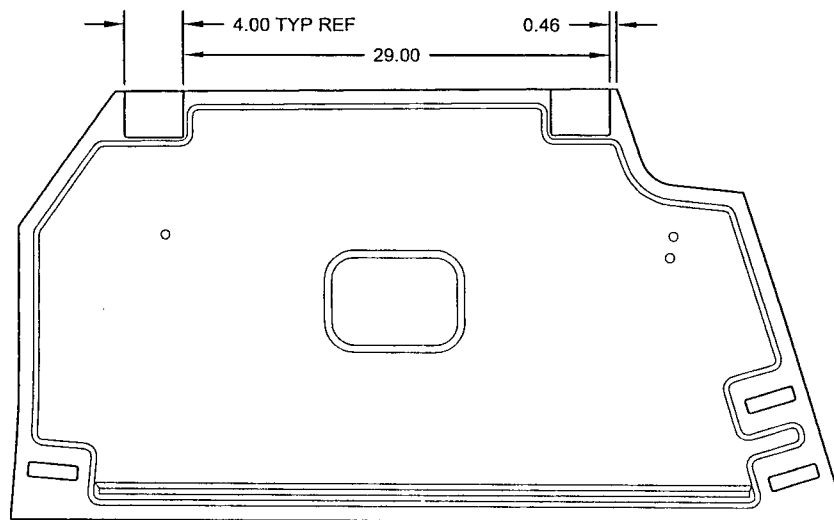
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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**D2991-1 SIDE DOOR**



**D2991-2 SIDE DOOR**



**D2991-3 SIDE DOOR**

**REFERENCE ONLY**

DESIGN	<b>Q</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<b>Q</b>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSK 123	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

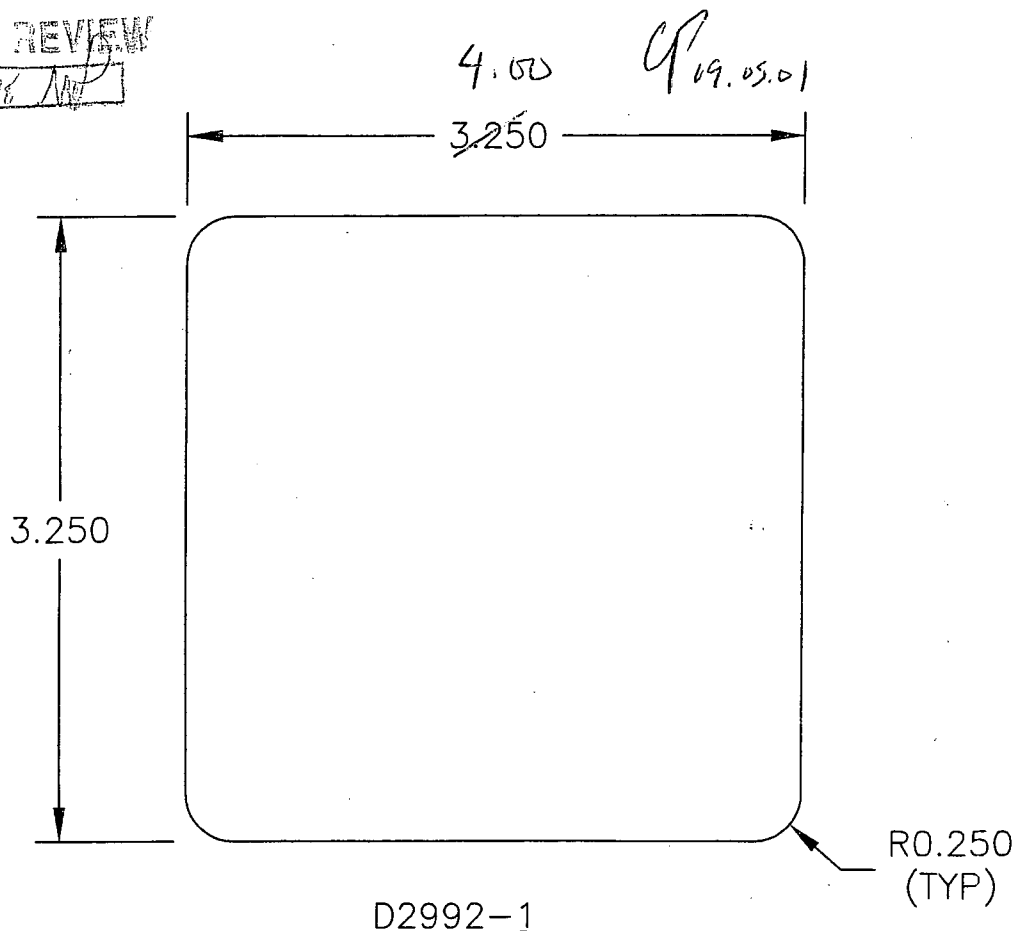


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED  
02.01.21

UNDER REVIEW  
07/03/16

REFERENCE ONLY



NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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REFERENCE ONLY

## 52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER  
REF. TCCA STC: SH92-41  
REF. FAA STC: SH1012NE  
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x  $\varnothing 0.129$  (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.

The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

## PARTS LIST







QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.02.03  
CERT. NO.: SH92-41  
ISSUE NO.: 7

A	NEW ISSUE		09.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9446	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SWITCH RELOCATION	NTS
DATE	09.02.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER  
REF. TCCA STC: SH92-41  
REF. FAA STC: SH1012NE  
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x Ø0.129 (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes Ø0.179 x 100° from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

### PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.02.04  
CERT. NO.: SH92-41  
ISSUE NO.: 7

A	NEW ISSUE	BY	09.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9447	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT	NTS
DATE	09.02.04	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries